

Date: Friday, 5/25/2007 8:17:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 32590	
Estimate Number : 11221	
P.O. Number : <i>N/A</i>	Part Number : D3350041
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3350 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31663	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/31/2007 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.05.25	
Comment : Est:B 05.07.11 Powder Coat now done after assembly KJ/JL M	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
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Comment: Qty.: 1.3234 f(s)/Unit Total : 6.6171 f(s)
 6061-T6 Bar .75" x .75"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B0.750x00.750)
 Identify for D3350-1
 Batch: *M100157 X6*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 0.750" x 0.750" x 15.00" long

J.L 07/06/10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3350-1 as per Folio FA496 and Dwg D3350
 Identify as D3350-1

J.L 07/06/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:17:12 AM
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Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/06/11

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble and Deburr

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

09-06-13 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/06/13 x6

9.0

D23245

Strap



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Strap

Pick:

Qty Part Number Description Batch

2 D2324-5 Strap

B27050B X12

B32045B(12)

✓

10.0

AN312A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Bolt

Pick:

Qty Part Number

Description

Batch

2 AN3-12A

Bolt

M 18310

X12

✓

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~20.0000~~ Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD10

Washer

M 104118

X24

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: STRUT

Job Number: 32590

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~10.0000~~ Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M103691

X12



13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3350.

Identify as D3350-041 and batch number using a fine point permanent marker

N/A

m107/06/13

X6

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/13 (6)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BUR/m.d 07-06-14

(6)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/6/14 (6)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/6/14 (6)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/14

Job Completion



W 07/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

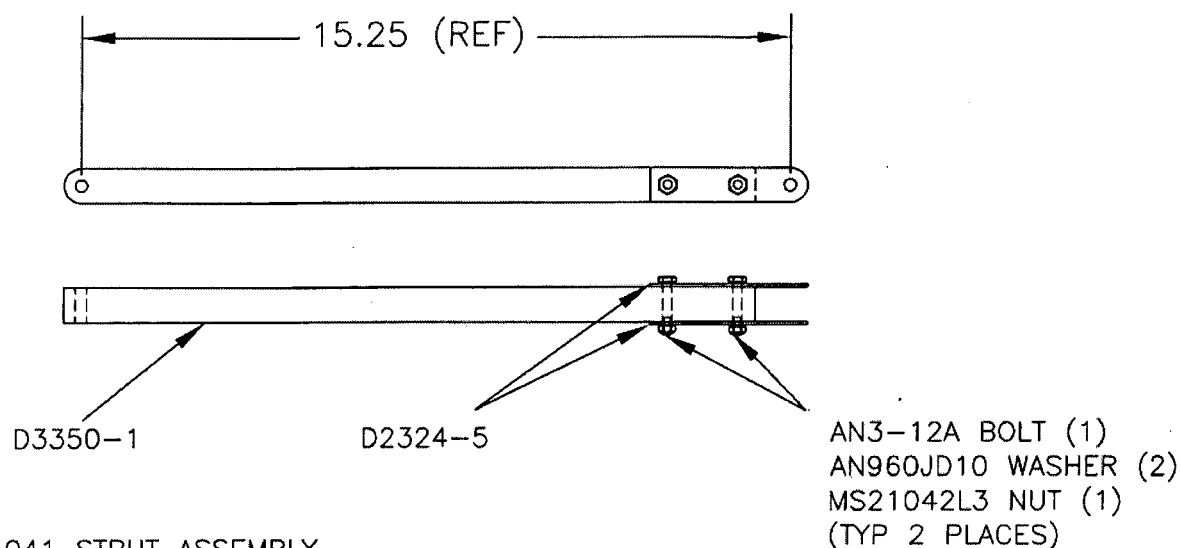
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

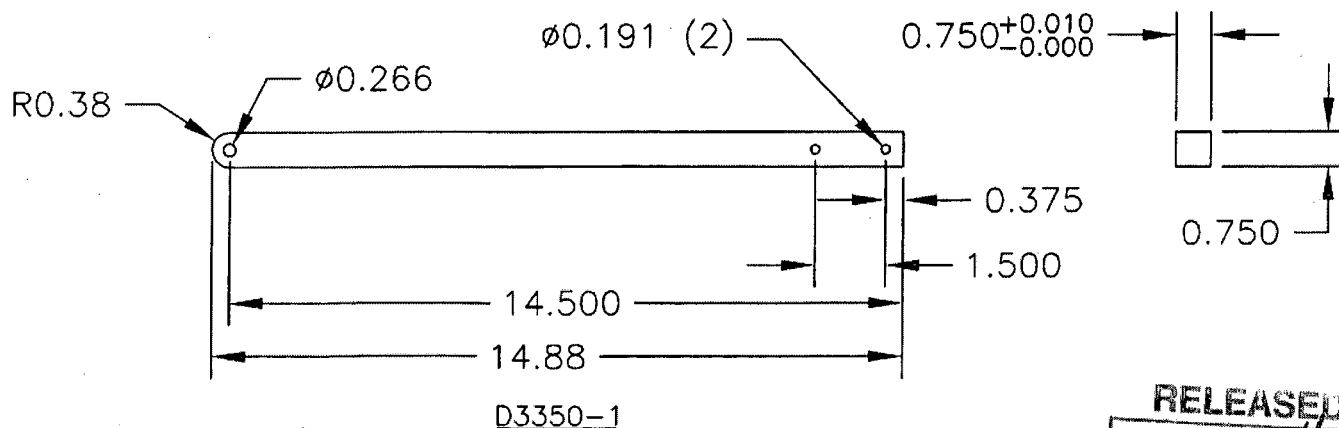


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A	04.11.12	NEW ISSUE	



D3350-041 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

RELEASED

04.12.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32590

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